### Work Order ID 54008

November 25, 2009 3:05:00 PM



Page 1

Item ID:

D2594-1

C

Revision ID: Item Name:

Plug, 205 Skidtube

Required Date: 11/30/09

**Start Date:** 

11/25/09

QC:

**Start Qty: 120.00** Req'd Qty: 120.00

Accept

**Cust Item ID: Customer:** 

Stop

Setup Start

Reference:

Approvals:

Process Plan:

Operation

Date:

Date:

Tooling: SPC (Y/N): Date:

Date:

Start

Stop

Set Up/ **Run Hours**  Draw Number

Plan Draw Rev. Code

Reject Accept Qty Qty

Run

Reject Number Stamp

Insp.

Sequence ID/ Work Center ID **Draw Nbr** 

**Description Revision Nbr** 

D2594

Rev C

001

Hardinge

Hardinge CNC LATHE SMALL

Memo

10011126

Hardinge CNC Lathe Small

1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010

Memo

110

120

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

0.00

08/1/26

0.00 And odul 26

Quality Control

QC

QC8- Inspect parts - second check

121

Memo

0.00

Quality Control

Dart Aerospace Li	td
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W/O:			ORK ORDER CHAN	NGES						
DATE STEP		PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		·								
				A SAME IN PRO-						
					,					
									, , ,	
Part No	:	PAR #:	Fault Ca	tegory:	NCF	R: Yes	No DQ	<b>4</b> :	Date: _	
	Resolution: Disposition: QA: N/C C									
NCR:			WORK OR	DER NON-CONFOR	MANCE	(NCR	)			•
DATE	STEP	Description of NC		Corrective Action Section B			Sign & Verifica		Approval	Approval
	J	Section A	Initial Chief Eng	Action Description Chief Eng	on .	Sign & Date	Secti	on C	Chief Eng	QC Inspector
								,		
								ş.		

NOTE: Date & initial all entries

### Work Order ID 54008

November 25, 2009 3:05:00 PM

D2594-1

**Revision ID:** C

Item Name:

Plug, 205 Skidtube

**Start Date:** 

Item ID:

11/25/09

**Start Qty: 120.00** 

Required Date: 11/30/09

Req'd Qty: 120.00



Accept



Setup Start



Stop

Reference:

Approvals:

**Process Plan:** 

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

**Cust Item ID:** 

**Customer:** 

Date:

Run

Start Stop

Sequence ID/ Work Center ID

130

HandFinish

Hand Finishing

**Operation** 

Chemical Conversion Coat per QSI005 4.1

Description

Set Up/ Run Hours

Draw Number 09-11-27.

Rev.

Draw

Plan Qty Code

Reject Accept Qty

Reject Insp. Number Stamp

121

140

Powdercoat

**Powder Coating** 

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

0.00

OVEN TEMPERATURE:

BY 09-10-2

150

QC3- Inspect Part Finish

0.00

Quality Control

Memo

0.00

MD 09/12/02

X121

## **Dart Aerospace Ltd**

<del>-</del> -		— - <del></del>							
W/O:			WC	ORK ORDER CHANG	ES	·			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							•		
								-	
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	\:	Date:	<u> </u>
Resolution:			Dispositio	n:	_ QA: N/C Cld	sed:		Date:	
NCR:		:	WORK ORD	ER NON-CONFORMA	ANCE (NCR	)			
DATE	STEP	Description of NC		<del>- 'h</del>	ion B	Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector
						:			
		,						:	
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		-							

NOTE: Date & initial all entries

## Work Order ID 54008

November 25, 2009 3:05:01 PM

Page 3

Item ID:

D2594-1

**Revision ID:** C

Item Name:

Plug, 205 Skidtube

**Start Date:** 

11/25/09

**Start Qty: 120.00** 

Required Date: 11/30/09

Req'd Qty: 120.00



Reference:

Approvals:

**Process Plan:** 

QC:

Date: Date: **Tooling:** 

SPC (Y/N):

Accept

Sequence ID/ Work Center ID

160

Packaging Packaging

Operation **Description** 

Identify as per dwg & Stock Locatio

Memo

Set Up/ **Run Hours** 

0.00

0.00

Setup Start



Stop

**Cust Item ID:** 

**Customer:** 

Date:

Date:

Run

Start

Stop

Draw Number Draw Rev.

Plan Code Accept

Reject Qty

Reject Number

Insp. Stamp

170

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09/12/03 HJ

Work Order ID: 54008

Parent Item:

D2594-1RevC

Parent Item Name: Plug, 205 Skidtube

Comments:

Component Item ID/ Item Name

Replacement Mfg/ Item ID Purch

M6061T6R0.625

Purchased



6061-T6 Round Bar .625"



Last

112697

Location

Primary

Location

Item

No

Start Date: 11/25/09

Qty

Issued

Required Date: 11/30/09

**Start Qty: 120.00** 

Qty To Pick

Remaining

Qty on

108.3857 6.5811

Required Qty: 120.00

Date Issued

Status

Page 1

Warehouse	Loc Qty	Loc Code
<b>Location</b>		
Main Warehouse		
MAT	108.3857	•
109733	5.72	
110250	11.79	
111650	14.6157	
<b>—</b> 112611	16.26	

60

Route

Seq ID

110

Unit of

Measure Hand

6.8P/ Show11/26

	Dart	Aero	space	Ltd
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		WO	RK ORDER CHANG	ES				
DATE STEP PROC			IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					-			
			·					
:	PAR #:	Fault Categ	ory:	NCR: Ye	s No DO	PA:	Date: _	<u> </u>
		WORK ORDE	R NON-CONFORMA	NCE (NO	CR)			
CTED	Description of NC				Verif	ication	Approval	Approval
SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		n&   <sub>Sec</sub>		Chief Eng	QC Inspector
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		:PAR #: Resolution:	STEP PROCEDURE CHAN  PAR #: Fault Category  Resolution: Disposition  WORK ORDE  STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE  PAR #: Fault Category:  Resolution: Disposition:  WORK ORDER NON-CONFORMA  STEP Description of NC Section A Corrective Action Section A Corrective Action Description	PAR #: Fault Category: NCR: Ye  Resolution: Disposition: QA: N/C  WORK ORDER NON-CONFORMANCE (NO  STEP Description of NC	STEP PROCEDURE CHANGE By Date  :PAR #:Fault Category:NCR: Yes No DO Resolution:Disposition:QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng/Prod Mgr  :PAR #:Fault Category: NCR: Yes No DQA: Date:  Resolution:Disposition: QA: N/C Closed: Date:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	5400
Description: Plug	Part Number:	D2594-1
Inspection Dwg: D2594 Rev: C		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

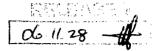
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	.059	/.			
0.500	+/-0.010	500	1			
Ø0.625	+/-0.010	0.625				
Ø0.430	+0.000/-0.002	0,430				
0.090	+0.000/-0.002	,090				
0.045	+0.000/-0.002	10435				
						/
					1	
				\		

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 8/11/26	Date: 09/11/26	Date:	

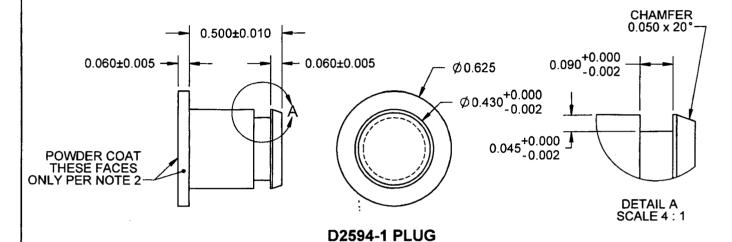
Rev	Date	Change	Revised by	Approved
Α	04.01.21	New Issue	, KJ/RF	
В	06.12.20	Dwg Rev. updated	KJ/JLM 1,A	N
С	08.07.23	Diameter symbol added	KJ/DD 🦮	



DESIG	N #	DRAWN BY	DART AEROSF HAWKESBURY, ONTA	
CHEC	KED	APPROVED,/	DRAWING NO.	REV. C
	=		D2594	SHEET 1 OF 1
DATE			TITLE	SCALE
	06.1	11.20	PLUG	2:1
 REV		DATE	DESCRIPT	ION
Α		96.09.16	NEWISSUE	
В		97.03.15	ADD GROOVE AND O-RING	j



	REV	DATE	DESCRIPTION
	Α	96.09.16	NEWISSUE
	В	97.03.15	ADD GROOVE AND O-RING
	С	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE



### D2594-1 PLUG NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
  3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

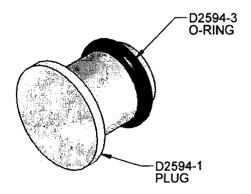
**D2594-3 O-RING NOTES:** 

1) 5/16 ID, 7/16 OD, 1/16 WIDTH 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011





QTY	P/N	DESCRIPTION
Х	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



## D2594 PLUG ASSEMBLY

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